

Work Order ID 112638

112638

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Item ID: 646.9501 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206 Cable Cutters High
 Start Date: 2/03/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/11/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.9500	N/C								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo <u>7.10.</u>	0.00			DAS 6 9-89				
Document Control	Photocopy bluefile & type labels per PPP 646.9501								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00			DAS 6 9-89				
Quality Control									

(X) M5 14 03 10

1X DAS 28 9-89 14-02-5

(A) _____



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Item ID: 646.9501

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/11/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP 646.9501
Location: 092

1 SL 14-03-10

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 14-03-11

14-03-10

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Work Order ID: 112638
Parent Item: 646.9501
Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14
Start Qty: 1.00

Required Date: 2/11/14
Required Qty: 1.00

Comments: IPP REV:A 12.08.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9601 Upper Cutter Assy DAS 6 9-89		Manufactured	No			110	Each	3.0000	1			DAS 28 9-89	14-02-5
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST428A		2						DAS 31 9-89	
				110634		2			IX				
				ST429		1							
				105804		1							
646.9602 Lower Cutter Assy High DAS 6 9-89		Manufactured	No			110	Each	2.0000	1			DAS 28 9-89	DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST429		2							
				108115		2			IX				
646.9810 Deflector DAS 6 9-89		Manufactured	No			110	Each	1.0000	1			DAS 28 9-89	DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST545		1							
				108293		1			IX				
647.0210 Rail DAS 6 9-89		Manufactured	No			110	Each	42.0000	1			DAS 28 9-89	DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST421		42							
				110632		4							
				91280		8							
				91440		30			IX				
647.0410 Roof Doubler DAS 6 9-89		Manufactured	No			110	Each	7.0000	1			DAS 28 9-89	DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST420		7							
				89703		5			IX				
				m126249		2							

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Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

647.0310 Channel	Manufactured	No	110	Each	30.0000	2	2	DAS 28 9-89	14-02-5
DAS 6 9-89			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			ST422		30				
			109494		4				
			90799		26				
646.9910 Struts	Manufactured	No	110	Each	190.0000	4	4	DAS 28 9-89	
DAS 6 9-89			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			ST420		39				
			104216		1				
			106009		4				
			106667		13				
			108738		7				
			109407		12				
			91269		2				
			ST420A		151				
			93189		151				
647.0112 Strut Bracket	Manufactured	No	110	Each	117.0000	8	8	DAS 28 9-89	
DAS 6 9-89			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			st535		117				
			89701		12				
			91264		102				
			92480		3				
647.0113 Strut Doubler	Manufactured	No	110	Each	15.0000	2	2	DAS 28 9-89	
DAS 6 9-89			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			ST421		15				
			89700		15				

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Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

647.0114 Panel	DAS 6 9-89	Manufactured	No		110	Each	4.0000	1	1	DAS 28 9-89	DAS 31 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				ST421	4						
				89763	4						
647.0116 Doubler		Manufactured	No		110	Each	43.0000	2	2	DAS 28 9-89	DAS 31 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				ST536	43						
				89699	2						
				m126249	41						
647.0410 Tube	DAS 6 9-89	Manufactured	No		110	Each	10.0000	1	1	DAS 28 9-89	DAS 31 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				ST536	10						
				106897	3						
				109587	3						
				110641	4						
647.0114 Clip		Manufactured	No		110	Each	100.0000	1	1	DAS 28 9-89	DAS 31 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				st535	100						
				106616	100						
647.0115 Clip		Manufactured	No		110	Each	95.0000	1	1	DAS 28 9-89	DAS 31 9-89
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				st535	95						
				106617	95						

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Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Washer

Purchased No

110 Each 10,799.000

111

111

DAS
28
9-89

14-02-5

DAS
6
9-89

Location

Loc Qty

Loc Code

ST295 799
123522 400
123900 399
st510 10000
125268 10000

111x

DAS
31
9-89

NAS1149F0332P

Washer

Purchased No

110 Each 6,674.0000

62

62

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA 205
122063 205
ST295 12
123900 12
ST510a 6457
125646 3957
m127831 2500

62x

DAS
31
9-89

AN3-11A

Bolt

Purchased No

110 Each 551.0000

8

8

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST511 500
m125709 500
ST512 51
123352 51

8x

DAS
31
9-89

MS21042-3

Nut

MS21042L3

Purchased No

110 Each 179.0000

17

17

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST313 179
123352 179

17x

DAS
31
9-89

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Work Order ID: 112638

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

CCR264SS-3-06

Rivet DAS
6
9-89

Purchased No

110 Each 54.0000

8 8

DAS

28

9-89

14-02-5

Location

Loc Qty

Loc Code

ST327

54

m126320

54

8x

DAS

31

9-89

Purchased No

110 Each 1,101.0000

4

DAS

28

9-89

Location

Loc Qty

Loc Code

ST508

1101

125654

1101

4x

DAS

31

9-89

Purchased No

110 Each 490.0000

26

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

390

123301

190

m127376

200

ST329

100

m127255

100

26x

DAS

31

9-89

Purchased No

110 Each 320.0000

20

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

320

123301

320

20x

DAS

31

9-89

Purchased No

110 Each 800.0000

19

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

500

126282

500

st552

300

123301

300

124876

DAS

31

9-89

CR3213-4-6

Rivet DAS
6
9-89

Purchased No

110 Each 320.0000

20

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

320

123301

320

20x

DAS

31

9-89

Purchased No

110 Each 800.0000

19

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

500

126282

500

st552

300

123301

300

124876

DAS

31

9-89

CR3213-4-4

Rivet DAS
6
9-89

Purchased No

110 Each 800.0000

19

DAS

28

9-89

Location

Loc Qty

Loc Code

ST328

500

126282

500

st552

300

123301

300

124876

DAS

31

9-89

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Work Order ID: 112638

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-2

Cherry Rivet

Purchased No

110 Each 900.0000

18

18

DAS

28

9-89

14-02-5

DAS
6
9-89

Location

Loc Qty

Loc Code

ST328

900

123301

492

m126320

408

18x

DAS
31
9-89

Purchased No

110 Each 1,000.0000

18

18

DAS

28

9-89

Location

Loc Qty

Loc Code

st552

1000

123301

1000

127831

DAS
31
9-89

Purchased No

110 Each 407.0000

6

6

DAS

28

9-89

Location

Loc Qty

Loc Code

ST315

1

123301

1

st507

406

125654

406

6x

DAS
28
9-89

DAS
31
9-89

Purchased No

110 Each 90.0000

54

54

DAS

28

9-89

Location

Loc Qty

Loc Code

ST313

90

123352

90

123525 (54x)

DAS
31
9-89

Purchased No

110 Each 612.0000

6

6

DAS

28

9-89

Location

Loc Qty

Loc Code

Mezz

92

4067

92

ST307

174

123352

174

6x

DAS
31
9-89

ST506

346

124326

346

DAS
6
9-89

MS21042-08

USE MS21042L08

DAS
6
9-89

MS27039-08-13

Screw

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Work Order ID: 112638

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

MS21059-3

Nut Plate

Purchased

No

110

Each

642.0000

2

2

DAS
28
9-89

14-02-5

DAS
6
9-89

Location

Loc Qty

Loc Code

ST316

642

123023

50

123301

92

123900

500

2x

DAS
31
9-89

AN743-13

Bracket

Purchased

No

110

Each

41.0000

1

1

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST347

41

M126010

9

M126119

12

M126249

20

1x

DAS
31
9-89

AN35A

Bolt

Purchased

No

110

Each

485.0000

1

1

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

st350

242

m126249

42

m127044

200

m127815

243

1x

DAS
31
9-89

CGR264SS3-04

Rivet

Purchased

No

110

Each

659.0000

12

12

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST327

659

123352

200

123785

400

17997

59

12x

DAS
31
9-89

CR3212-5-4

Cherry Rivet

Purchased

No

110

Each

210.0000

8

8

DAS
28
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST328

210

120410

103

123301

107

8x

DAS
31
9-89

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Page 8

Work Order ID: 112638

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

GCR264SS3-2

Rivet, Cherry

DAS
6
9-89

Purchased No

110 Each 388.0000

4

4

DAS
28
9-89

14-02-5

Location

Loc Qty

Loc Code

ST327

388

126363

200

m127580

188

72

4X

DAS
31
9-89

NAS1835-08

Insert

DAS
6
9-89

Purchased No

110 Each 44.0000

4

4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST298

44

123521

19

m126400

25

4X

DAS
31
9-89

CR3213-11

Cherry Rivet

DAS
6
9-89

Purchased No

110 Each 424.0000

14

14

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

424

123301

27

m126249

297

m126254

100

14X

DAS
31
9-89

MS27039-1-08

Screw

DAS
6
9-89

Purchased No

110 Each 901.0000

5

5

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

51

m125654

51

st507

850

m127255

500

m127813

350

5X

DAS
31
9-89

647-1210

Screen

DAS
6
9-89

Manufactured No

110 Each 7.0000

1

1

DAS
28
9-89

Location

Loc Qty

Loc Code

ST536

7

m126249

7

1X

DAS
31
9-89

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Parent Item: 646.9501

Start Date: 2/03/14

Required Date: 2/11/14

Parent Item Name: 206 Cable Cutters High

Start Qty: 1.00

Required Qty: 1.00

MS35842-11

Hose Clamp

DAS
6
9-89

Purchased

No

110

Each

10.0000

1

DAS
28
9-89

14-02-5

Location

Loc Qty

Loc Code

ST290

10

m128062

10

110

Each

426.0000

43

DAS
28
9-89

Location

Loc Qty

Loc Code

ST307

166

123352

166

ST506

260

122441

100

123900

160

43x

DAS
31
9-89

MS27039-08-06

Screw

DAS
6
9-89

Purchased

No

110

Each

244.0000

4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST307

244

117065

20

125646

100

m126249

124

4x

DAS
31
9-89

MS27039-08-09

Screw

DAS
6
9-89

Purchased

No

110

Each

133.0000

4

DAS
28
9-89

Location

Loc Qty

Loc Code

Mezz

51

11187

51

ST307

82

m127904

82

4x

DAS
31
9-89

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Work Order ID: 112638

Parent Item: 646.9501

Parent Item Name: 206 Cable Cutters High

Start Date: 2/03/14

Required Date: 2/11/14

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-12

Screw

Purchased

No

110

Each

249.0000

2

2

DAS
28
9-89

14-02-5

Location

Loc Qty

Loc Code

Mezz

7

1850

7

ST307

77

123352

31

123900

46

ST506

165

123352

65

124326

100

2x

DAS
31
9-89

MS27039-1-11

Screw

Purchased

No

110

Each

567.0000

5

5

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

33

9662

33

ST305

234

123352

99

125654

135

ST506

300

124326

300

5x

DAS
31
9-89

GR3212-4-4

CHERRY RIVET

Purchased

No

110

Each

200.0000

1

1

DAS
28
9-89

Location

Loc Qty

Loc Code

ST328

200

m128062

200

123265

DAS
31
9-89

MS24694-S8

Screw

Purchased

No

110

Each

90.0000

5

5

DAS
28
9-89

Location

Loc Qty

Loc Code

ST302

90

123352

90

5x

DAS
31
9-89

DAS

6

9-89

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 46 A/R TO FILL GAPS AND FILLET EDGES

UNINCORPORATED ECN(S)

02729, 02736, 03047

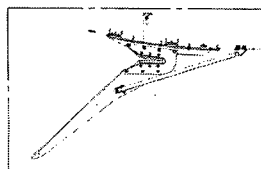
MAR 10 2014
MAR 10 2014

MAR 10 2014

DETAIL A

REFERENCE ONLY

DAS
6
9-89



DETAIL B

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	49	601.1066	RIVET		
1	48	601.1066	MAGNIFORMID ASSY PART B		
1	47	601.1066	MAGNIFORMID ASSY PART A		
1	46	601.1066	SEALANT		
5	45	601.1949	SCREW		
2	44	601.2989	SCREW		
4	43	601.2987	SCREW		
4	42	601.3000	SCREW		

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
47	47	41	601.2693	SCREW	
1	40	601.2982	HOSE CLAMP		
1	39	601.2982	SCREEN		
5	38	601.1621	SCREW		
14	37	601.2979	RIVET		
4	36	601.2984	INSERT		
4	35	601.2277	RIVET		
8	34	601.2983	RIVET		
12	33	601.2980	NUTPLATE RIVET		
1	32	601.2822	BOLT		
1	31	601.2985	BRACKET		
2	30	601.1900	NUTPLATE		
6	29	601.2988	SCREW		
53	28	601.2973	LOCKNUT	MS21042-08	
6	27	600.0795	NUTPLATE		
18	26	601.0790	RIVET		
18	25	601.1039	RIVET		
19	24	601.1915	RIVET		
20	23	601.2991	RIVET		
26	22	601.1183	RIVET		
4	21	601.2356	NUTPLATE		
8	20	601.2981	NUTPLATE RIVET	CCP2415.876	
17	19	601.2943	LOCKNUT	MS21042-08	
16	18	601.2826	BOLT	ANSI-11A	
46	17	601.1607	WASHER	MS21042-08	
114	16	601.2764	WASHER	MS21042-08	
1	15	601.2764	CLIP		
1	14	601.2764	CLIP		
1	13	601.2764	TUBE		
2	12	601.2764	DOUBLER		
1	11	601.2764	PANEL		
2	10	601.2764	STRUT DOUBLER		
8	9	601.2764	STRUT BRACKET		
4	8	601.2764	STRUT		
2	7	601.2764	CHANNEL		
1	6	601.2764	ROOF DOUBLER		
1	5	601.2764	RAIL		
1	4	601.2764	DEFLECTOR		
1	3	646.9503	LOWER CUTTER ASSY LOW		
2	2	646.9503	LOWER CUTTER ASSY HIGH		
1	1	646.9501	UPPER CUTTER ASSY		
		646.9502	206 CABLE CUTTERS KIT LOW		
		646.9501	206 CABLE CUTTERS KIT HIGH		

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1	49	601.1066	RIVET		
1	48	601.1066	MAGNIFORMID ASSY PART B		
1	47	601.1066	MAGNIFORMID ASSY PART A		
1	46	601.1066	SEALANT		
5	45	601.1949	SCREW		
2	44	601.2989	SCREW		
4	43	601.2987	SCREW		
4	42	601.3000	SCREW		

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

206 CABLE CUTTERS KIT

SCALE: NONE

SHEET 1 OF 3

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02736				SHEET 1 OF 1	
	DWG NO. 646.9500	REV: N/C	PREPARED BY S. HUFF	DATE: 01/06/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: 206 CABLE CUTTERS KIT					
	APPROVED BY:	ENGR. <i>[Signature]</i>	MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: CORRECTED PARTS LIST ERRORS					

17	R	601.1607	62	62	WASHER	NASH149F0332P
16	R	601.2764	111	111	WASHER	NASH149F0832P
			9502	9501		
F/N	TC	PART NUMBER	QTY		DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM						CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
						DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

<h1 style="margin:0;">APICAL</h1> <p style="margin:0;">INDUSTRIES, INC.</p>		ENGINEERING CHANGE NOTICE NO. 02729				SHEET 1 OF 3	
		DWG NO. 646.9500	REV: N/C	PREPARED BY S. HUFF	DATE: 12/23/09	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
		DWG TITLE: 206 CABLE CUTTERS KIT					
		APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: HARDWARE REVISIONS FROM FIRST INSTALL					
51	A	601.3155	8	8	BOLT	AN3-10A	
50	A	601.3153	5	5	SCREW	MS24694S8	
41	R	601.2893	43	43	SCREW	MS27039-0811	
28	R	601.2973	54	54	LOCKNUT	MS21042-08	
18	R	601.2826	8	8	BOLT	AN3-11A	
16	R	601.2764	127	127	WASHER	NAS1149FN832P	
			9502	9501			
F/N	TC	PART NUMBER	QTY	DESCRIPTION		MATERIAL/SPECIFICATION	
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRUC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

Work Order ID 112781

February-06-14 2:40:12 PM

112781

Page 1

Item ID: D212-664-201TRN

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Turning Detail

Start Date: 2/06/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/20/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 14-02-06 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev D								

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AD

DWG REV: D

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 φ Kc
14-2-22

110

QC1- Inspect dimensions to dimension sheet.

0.00

110

QC

Memo

0.00

Quality Control

1 φ Kc
14-2-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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